304 - 150

Ship Tues 15

Work Order ID 67538

Monday, March 28, 2011 9:49:17 AM

Item ID: D2282-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Tube

Start Date: 3/28/2011 **Start Qty:** 150.00 **Cust Item ID:**

Required Date: 4/4/2011 **Req'd Qty:** 150.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-03-28 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2282	Rev E								
100	DOOSAN LATHE	0.00				150			
Doosan	**Memo**	0.00							
Doosan Lathe	1-Turn as per Dwg D2282 and Folio FA189								
	2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				150			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				150			
QC	**Memo**	0.00							
Quality Control									

RQ 11-5-18

RQ 11-5-18

11/5/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67538

Monday, March 28, 2011 9:49:17 AM

Item ID: D2282-5 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Tube

Start Date: 3/28/2011 **Start Qty:** 150.00 **Cust Item ID:**

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00				11/5/24		150	
Packaging	*****STOCK IN LARGE FAB*****								
140	QC21- Final Inspection - Work Order Release	0.00					11/5/26		
QC	**Memo**	0.00							
Quality Control									

MF
11-05-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 9:49:23 AM

Work Order ID: 67538

Parent Item: D2282-5

Parent Item Name: Tube

Start Date: 3/28/2011 **Required Date:** 4/4/2011

Start Qty: 150.00 **Required Qty:** 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	45.9400	0.18006	28.43053			

304 SS Roundbar .750

Location	Loc Qty	Loc Code
MAT028	45.94	
116501	21.86	
116623	24.08	

11.5.18

16.461'

29.749'

13.288'

117481

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

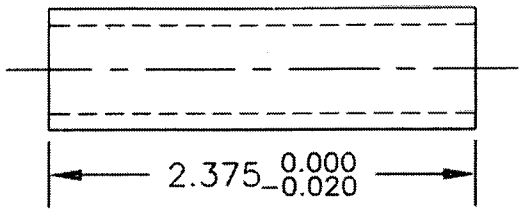
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

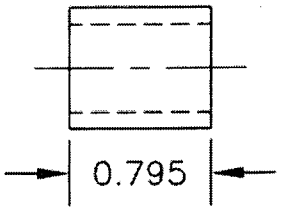
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW			
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2282	SHEET 1 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1

RELEASED
05/09/16

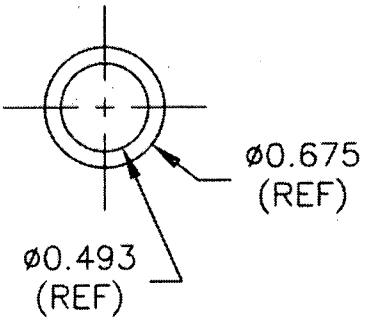
A	94.10.14	NEW ISSUE
B	95.03.23	RE-DESIGN
C	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



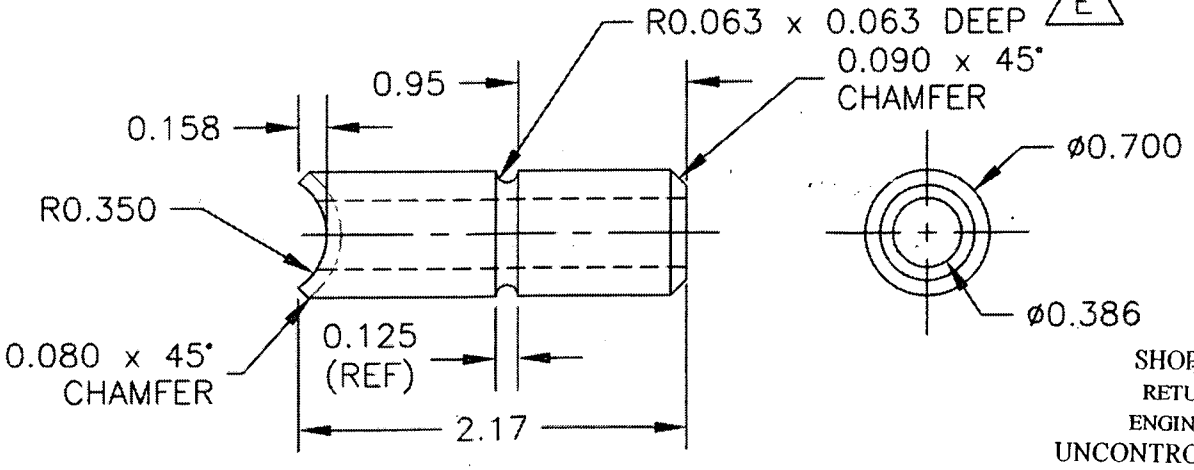
D2282-3



△D **D2282-7**



D2282-3/-7 TUBE:
1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



△D **D2282-5**

D2282-5 STEM:
1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDM
WITHOUT NOTI
WORK ORD
NO. 67536

△E

PS 11-03-24

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

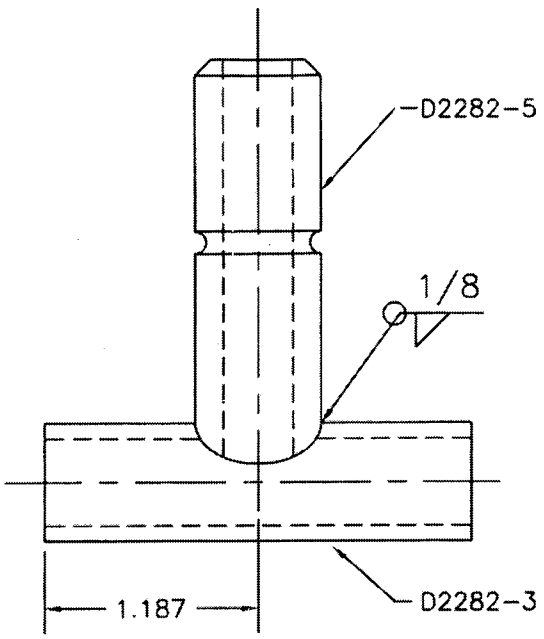
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

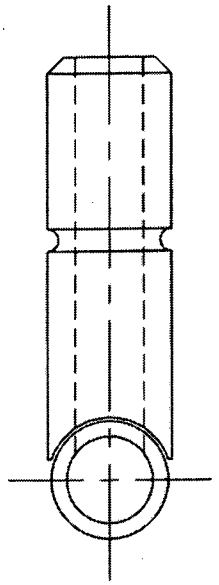
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW			
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1

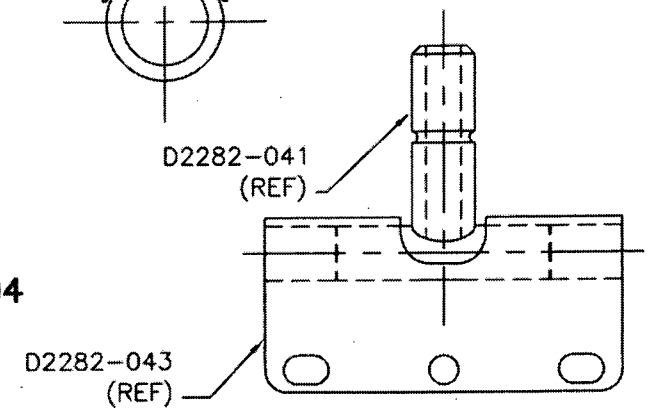
RELEASED
05/09/16





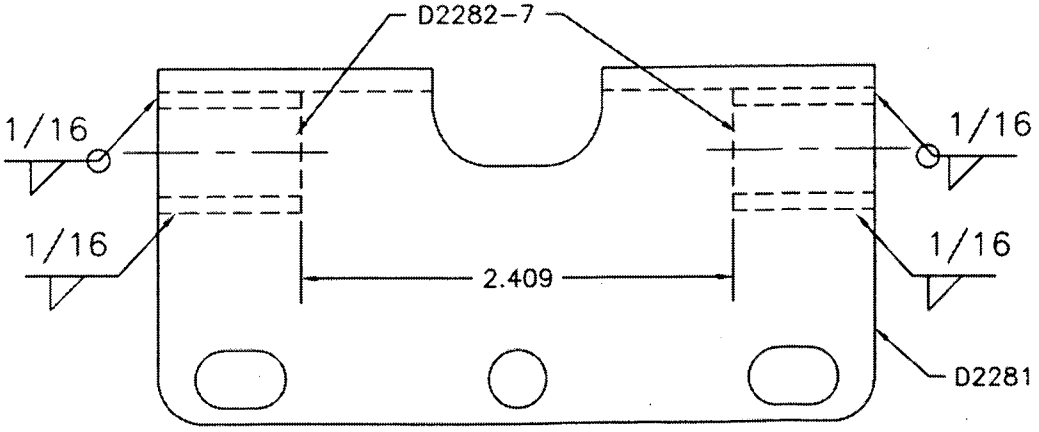
D2282-041 'T' ASSEMBLY

WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY

SCALE 1:2



D2282-043 SADDLE ASSEMBLY

WELD ASSEMBLY PER DART QSI 004

W047538

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 **Rev:** E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.153	✓		R .02	
R0.063	+/-0.010	2. 063	✓			
0.063	+/-0.010	.063	✓			
0.125	+/-0.010	.125	✓			
0.090 x 45°	+/-0.010	.093	✓			
R0.350	+0.010/-0.000	2.350	✓		R.G.	
0.158	+/-0.010	.148	✓		R .02	
Ø0.386	+0.005/-0.000	.386	✓			
Ø0.700	+/-0.010	.703	✓			

Measured by:	RG
Date:	11 · 5 · 18

Audited by:	
Date:	11/6/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	